

Work Order ID 66912

Wednesday, March 02, 2011 2:30:44 PM



Page 1

Item ID: D3442-3

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 3/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-03-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3442

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3442 ☐ Dwg Rev: A ☐ Prog Rev: 1 ☐ 2-
Deburr if necessary

B 11-3-3

9

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-3-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 ulos/oz

49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Shim

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Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

SAO

(9)

Packaging

*****STOCK IN BASKET CELL*****

11-03-03

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/04 *[Signature]**MR*

11-03-03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 02, 2011 2:30:50 PM

Page 1

Work Order ID: 66912

Parent Item: D3442-3

Parent Item Name: Shim




Start Date: 3/2/2011

Required Date: 3/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.09.02 New issue KJ/JLM
IPP B 07.07.23 waterjet EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	47.2896	0.025	0.105263		5	

304/316 .032 Sheet



HB11-3-3

Location

Loc Qty

Loc Code

MAT20

47.2896

109023

16.2896

109057

31

109057

9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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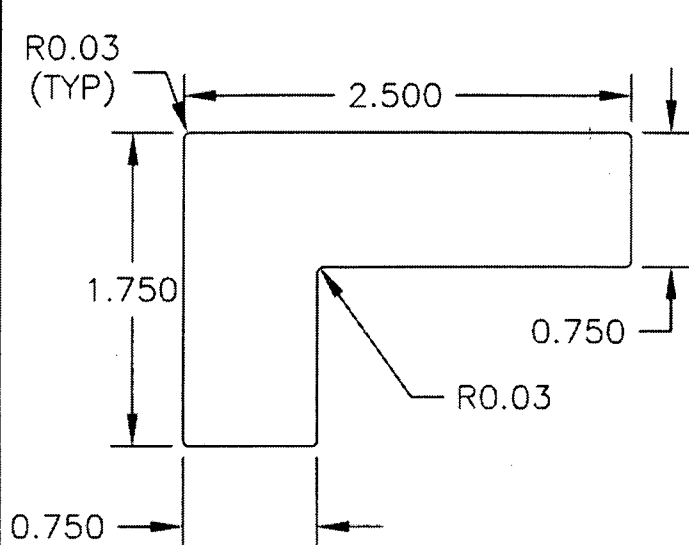
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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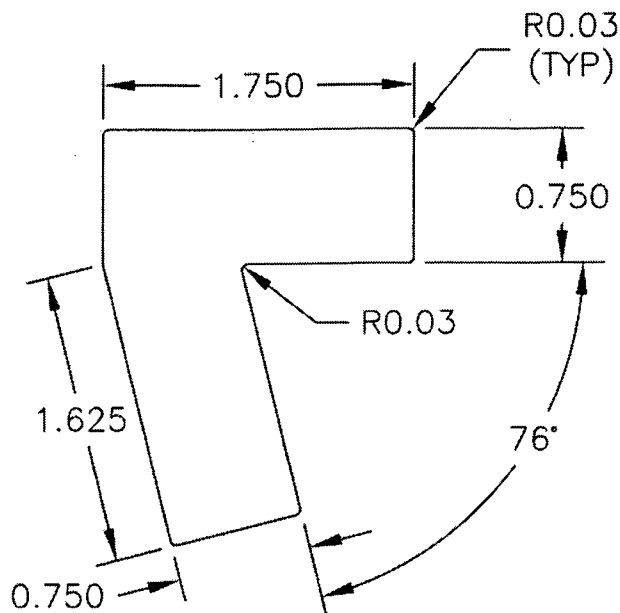
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	



D3442-1

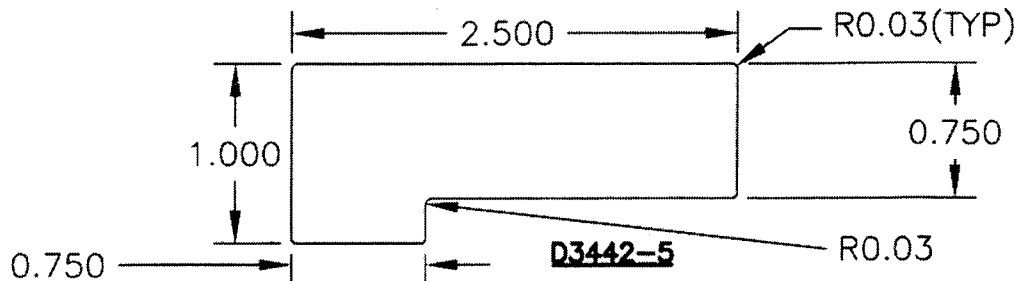


D3442-3

D3442-1/-3 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED BY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66912



D3442-5

D3442-5 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.08.19 *[Signature]*

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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